

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025062**Date Inspected:** 03-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 7000**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A	<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b> Yes No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b> Yes No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b> Yes No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b> Yes No N/A
				<b>Delayed / Cancelled:</b> Yes No N/A

**Bridge No:** 34-0006**Component:** Orthotropic Box Girder( OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

Blast Shop – 4

13AW

This QA Inspector performed Blast inspection on base metal, fillet welds and complete joint penetration (CJP) welds from panel point (PP) 119.65 to PP120 on internal surface of vertical plate, side panel, edge panel and bottom panel, Bottom plate T-rib, Side plate I-rib Following points were noted today morning after Blast Inspection of 14 West:

AT East side of PP119.65:

-Seg3013D: Section AY2 [C4 (of weld map)] - RS web to Flange - grinding notch observed.

-FB3194A: Base metal depression (of dia approx 75mm x 5mm deep) observed on X4157A stiffener plate of

---

## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

---

FB3194A.

-FB3194A: Base metal damage (dia 20mm x 5mm deep - approx) observed on X4157A stiffener plate of FB3194A.

-Seg3013D: Base metal damage (of dia approx 25mm x 6mm deep) observed on Bottom Panel (SA3168A) (between 2nd and 3rd RS stiffeners - from W13).

-Seg 3013D: Base metal damage (between 3rd and 4th RS3439D stiffeners - from KP3016A and at east side of FB3194A, near FB to SP weld) observed on SP3101A.

AT West side of PP120:

-Seg3013B: Base metal damage (of approx 20mm x 5mm deep) observed on Bottom Panel (SA3168A) (between 2nd and 3rd RS stiffeners - from W13).

-Seg3013B: Base metal damage (of approx 20mm x 5mm deep) observed on Bottom Panel (SA3168A) (between 2nd and 3rd RS stiffeners - from W13).

All information regarding this marked on weld map and submitted to Lead QA Inspector.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

### Summary of Conversations:

No significant conversations were reported on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey - 15000026784, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Prabhune,Manoj	Quality Assurance Inspector
<b>Reviewed By:</b>	Peterson,Art	QA Reviewer

---